



US009573325B2

(12) **United States Patent**
Davis et al.

(10) **Patent No.:** **US 9,573,325 B2**
(45) **Date of Patent:** **Feb. 21, 2017**

(54) **MOULD SHELL SECTION FOR A MOULD SHELL FOR A WIND TURBINE BLADE, MOULD SHELL AND METHOD USING THE MOULD SHELL SECTIONS**

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(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 107 days.

(21) Appl. No.: **14/369,948**

(22) PCT Filed: **Dec. 20, 2012**

(86) PCT No.: **PCT/DK2012/050488**

§ 371 (c)(1),

(2) Date: **Jun. 30, 2014**

(87) PCT Pub. No.: **WO2013/097859**

PCT Pub. Date: **Jul. 4, 2013**

(65) **Prior Publication Data**

US 2014/0338815 A1 Nov. 20, 2014

Related U.S. Application Data

(60) Provisional application No. 61/583,669, filed on Jan. 6, 2012.

(30) **Foreign Application Priority Data**

Dec. 30, 2011 (DK) PA 2011 70771

(51) **Int. Cl.**
B32B 41/00 (2006.01)
B29C 70/34 (2006.01)

(Continued)

(52) **U.S. Cl.**
CPC **B29C 70/345** (2013.01); **B29C 33/30** (2013.01); **B29C 33/301** (2013.01);
(Continued)

(58) **Field of Classification Search**
CPC B29C 70/345; B29C 33/30; B29C 33/301; B29C 33/303; B29C 33/005; B29C 70/34; B29D 99/0025; Y02P 70/523; B29L 2031/08; B29L 2031/085
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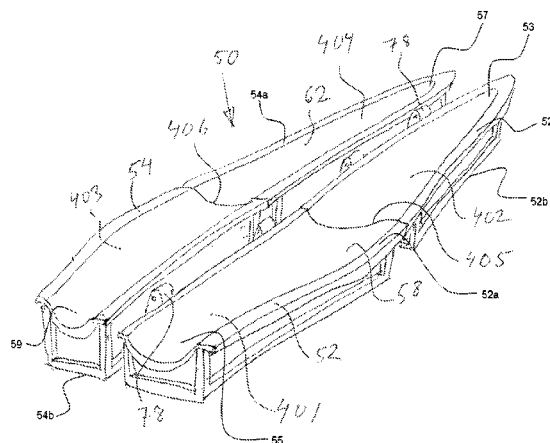
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(57) **ABSTRACT**

A mold shell for forming a wind turbine blade (20) comprises at least two mold shell sections (401, 402) each



having a mold surface with a recessed portion (419, 420) adjoining the connecting edges (407, 408) between the mold shell sections. A bridging sheet (421) is accommodated in the recessed portions (419, 420) of the mold shell sections (401, 402). The bridging sheet (421) fills up the recessed portions.

19 Claims, 8 Drawing Sheets

(51) **Int. Cl.**

B29C 33/30 (2006.01)

B29D 99/00 (2010.01)

B29L 31/08 (2006.01)

B29C 33/00 (2006.01)

(52) **U.S. Cl.**

CPC **B29C 33/303** (2013.01); **B29D 99/0025**
(2013.01); **B29C 33/005** (2013.01); **B29C**
70/34 (2013.01); **B29L 2031/08** (2013.01);
B29L 2031/085 (2013.01); **Y02P 70/523**
(2015.11)

(58) **Field of Classification Search**

USPC 156/64, 273.9, 350, 378, 379; 264/102,
264/105, 258, 261, 511

See application file for complete search history.

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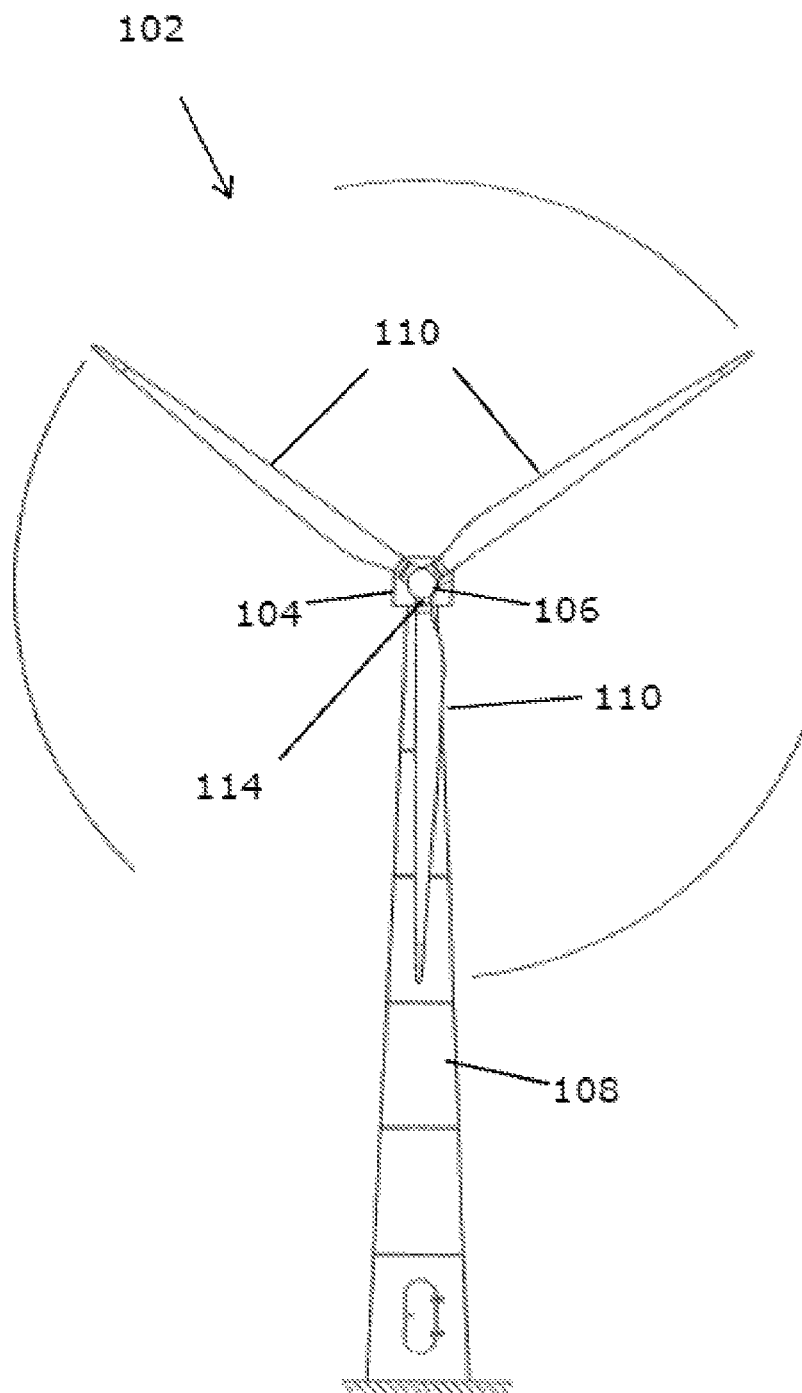
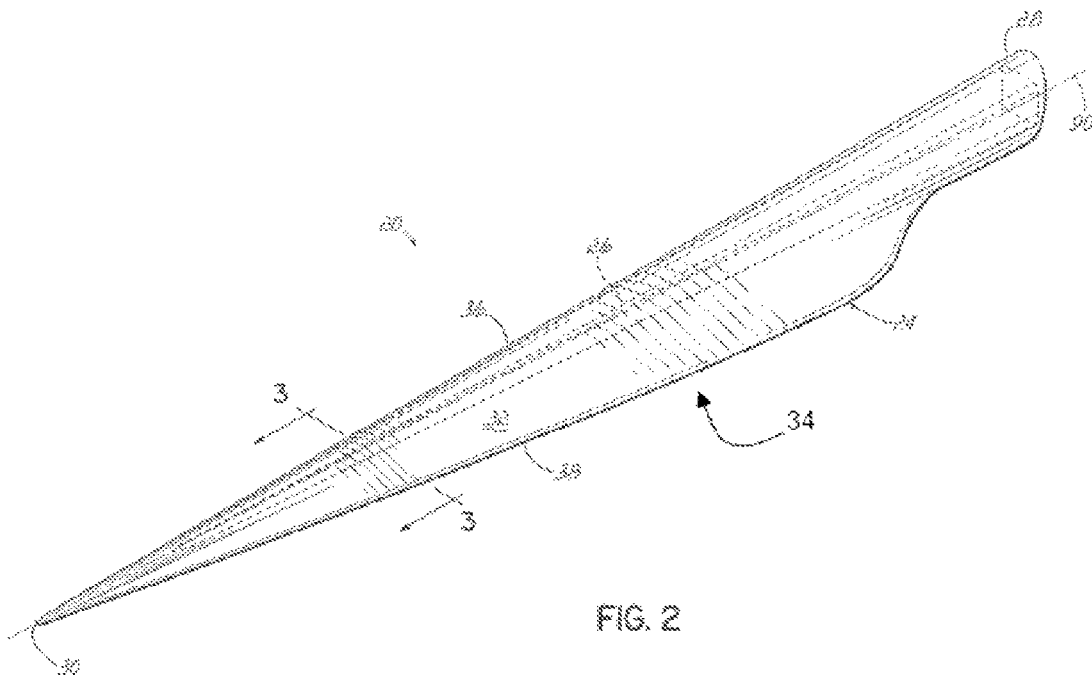


Fig. 1



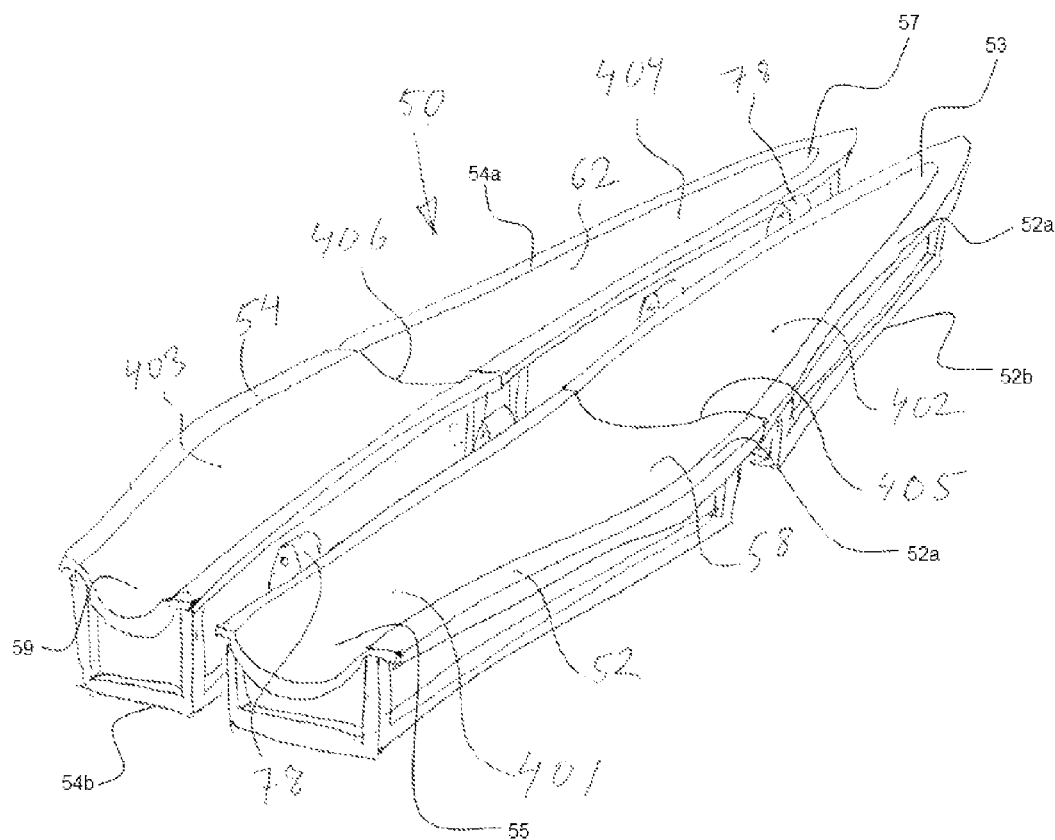


Fig. 3

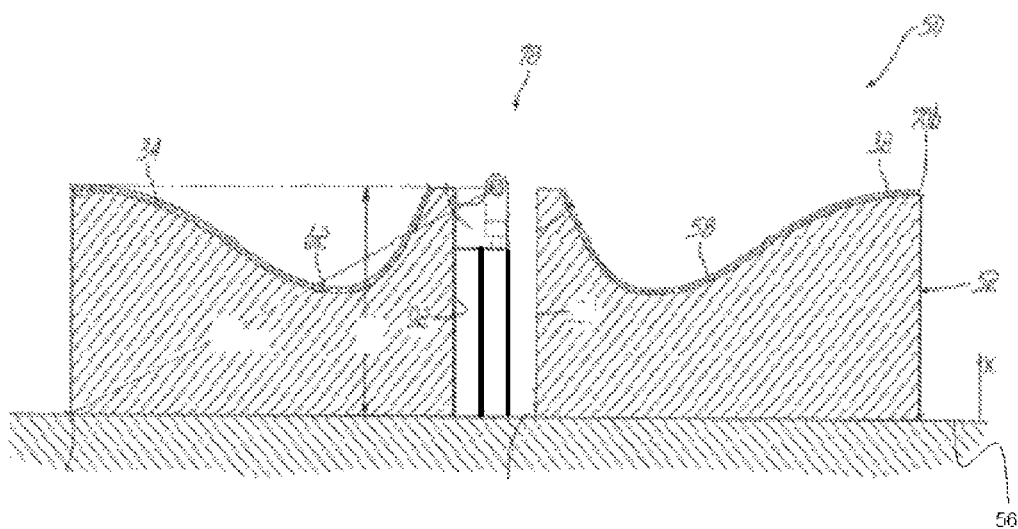


Fig. 4

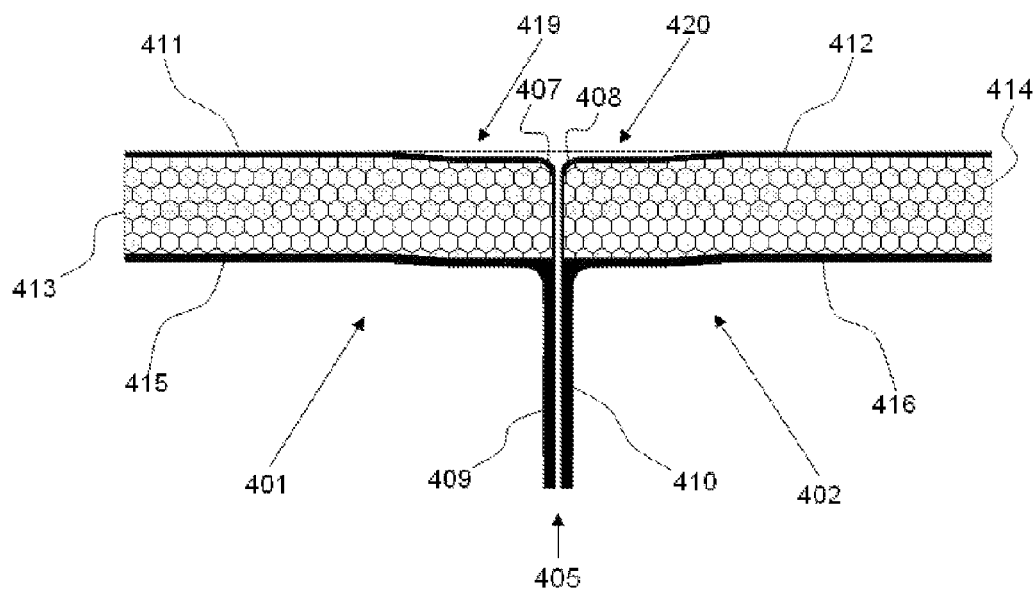


Fig. 5a

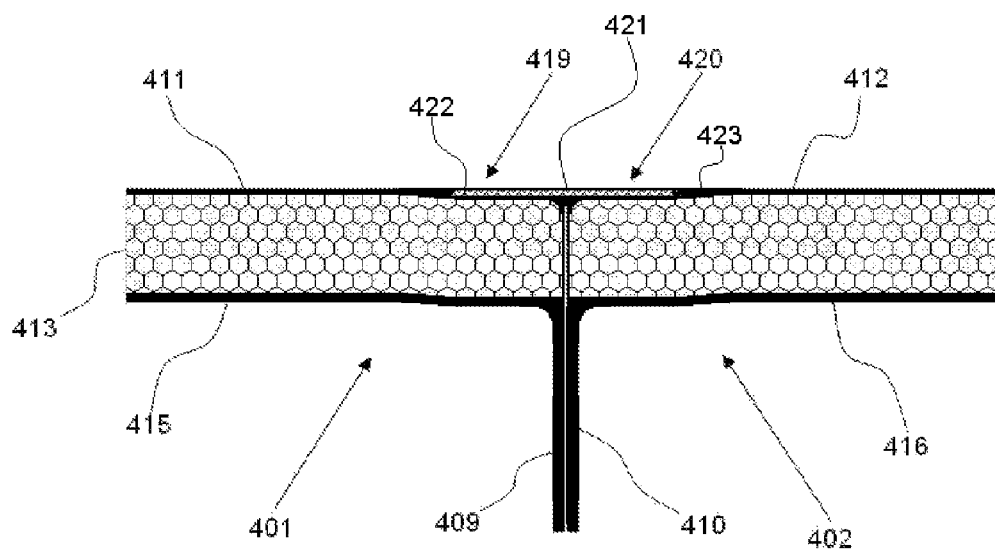


Fig. 5b

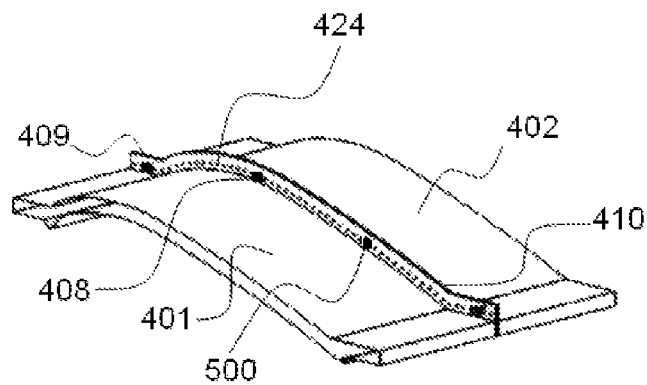


Fig. 6

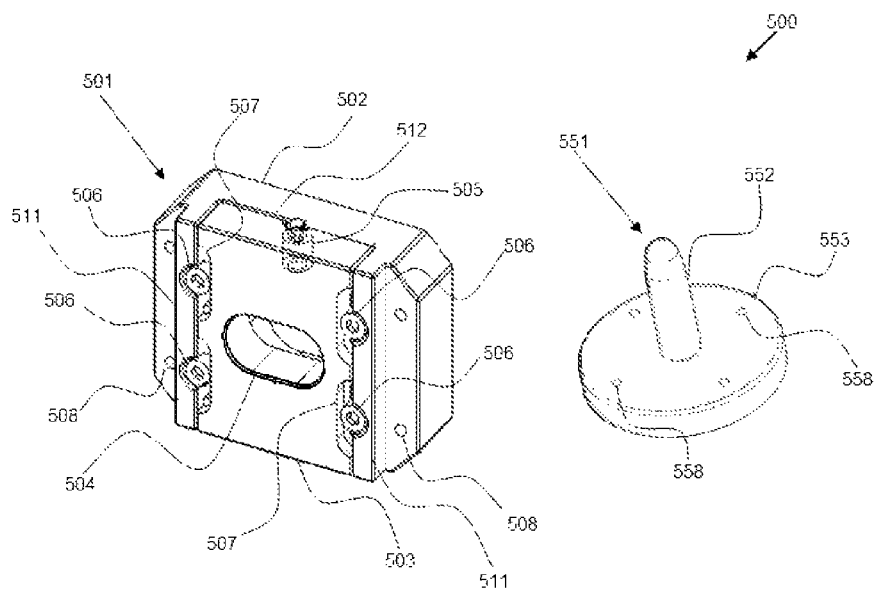


Fig. 7

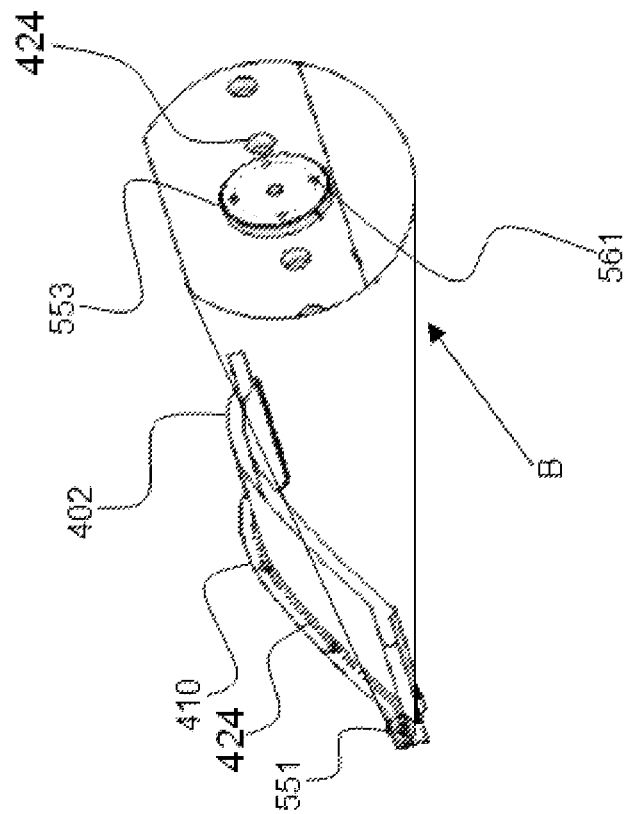


Fig. 8a

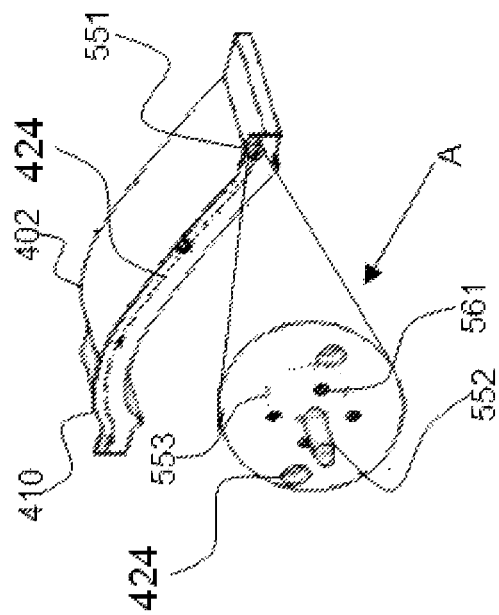


Fig. 8b

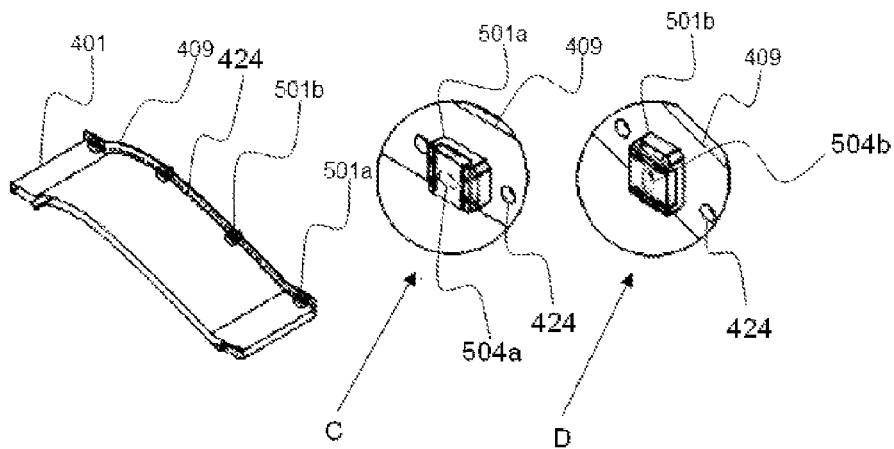


Fig. 9

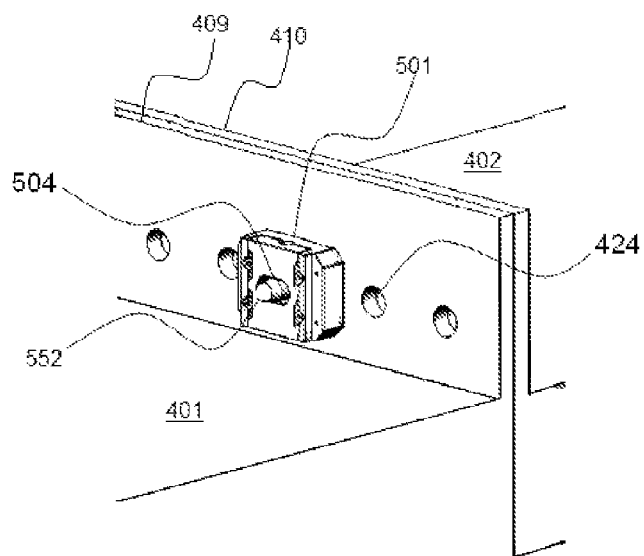


Fig. 10

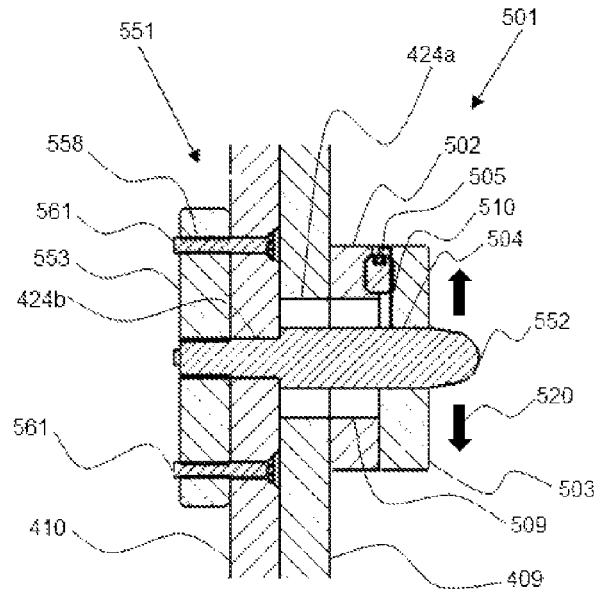


Fig. 11

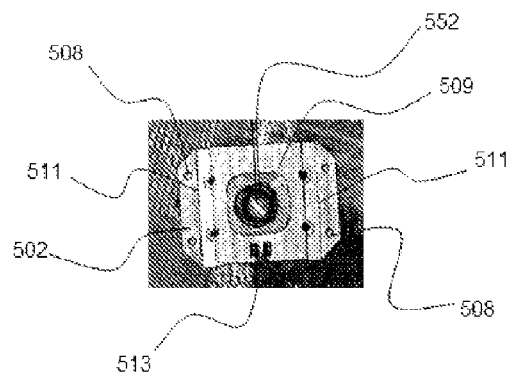


Fig. 12

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**MOULD SHELL SECTION FOR A MOULD
SHELL FOR A WIND TURBINE BLADE,
MOULD SHELL AND METHOD USING THE
MOULD SHELL SECTIONS**

BACKGROUND OF THE INVENTION

The present invention is directed to a mould shell section for a mould shell for forming a wind turbine blade, to a mould shell for forming a wind turbine blade, to adjustment means for adjusting adjacent mould shell sections to each other, and a method for providing a smooth transition between adjacent mould shell sections.

DESCRIPTION OF THE RELATED ART

A typical wind turbine as known in the art comprises a tapered wind turbine tower and a wind turbine nacelle positioned on top of the tower. A wind turbine rotor with a number of wind turbine blades is connected to the nacelle through a low speed shaft, which extends out of the nacelle front, as illustrated in FIG. 1. A radius of the rotor influences the performance of the wind turbine. For example, a wind turbine with an increased radius may deliver power even in lighter wind conditions. Likewise, a wind turbine with an increased radius may deliver more power than a given wind turbine. The radius of the rotor is substantially determined by a length of the wind turbine blades. Hence, the blades of recently erected wind turbines have become longer and longer. The length of the blades of the wind turbine in the shown example is approximately 40 meter, but blade lengths between 25 and 70 meters are also usual.

Production facilities for the blades have to adapt to their increasing size. Outer shells of wind turbine blades are usually laminates formed from a fibre-reinforced composite, such as a resin reinforced by a fibre material such as glass fibre material or carbon fibre material, or a combination thereof. Hence, moulds for forming the fibre-reinforced composite of the outer shells have to be adjusted in their size and become just as long as the blades or even slightly longer.

Since the blades became longer and longer, road transport of the blades has been increasingly difficult as roads are not dimensioned for these long transport vehicles. Likewise, the moulds having about the same size as the blades are difficult to transport, such that production facilities for full size moulds have to be established in the neighbourhood of the production facilities for the blades.

Recently, rotor blades have been moulded in parts which may be arranged across the length of the rotor blade. Accordingly, DE 198 33 869 C5 discloses a mould for wind turbine rotor blades formed of fibre-reinforced composites. The mould is split into mould parts. In each mould part a section of the blade is formed. The completed sections are put together thereafter.

Further, it is known from EP 2 316 629 A1 to provide a modular mould system comprised of a number of mould sections. The mould sections may be assembled to form a particular variation of a blade. A junction of one mould section to an adjacent mould section is formed by a flexible end segment. The end segment matches substantially the contour of the adjacent mould section. The end segment is adjusted to ensure a smooth transition between the two mould sections. In some embodiments the end segment is arranged to provide an overlap with the adjacent mould section.

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The object of the present invention is to provide for an improved transition between sections of a mould for a wind turbine blade.

SUMMARY OF THE INVENTION

The invention provides a mould shell section for a mould shell for forming a wind turbine blade comprising a mould surface for receiving a fibre-reinforced composite for a blade a connecting edge arranged laterally at the mould shell section, said connecting edge being adapted to provide an interface for another mould shell section of said mould shell; and said mould surface having a recessed portion adjoining said connecting edge, said recessed portion being adapted to accommodate a portion of a bridging sheet.

The invention further provides a mould shell for forming a wind turbine blade comprising at least two such mould shell sections, said mould shell sections engaging each other along their connecting edges, and a bridging sheet accommodated in the recessed portion of the mould shell sections wherein the bridging sheet is arranged to fill up the recessed portion.

The invention also provides an adjustment means for mutually adjusting first and second mould shell sections of a mould shell for forming a wind turbine blade, said adjustment means comprising a frame for attachment of said adjustment means to the first mould shell section; a guide part being adapted to engage the second mould shell section and being adapted to slide in the frame in an adjustment direction to guide an engagement position of the first mould shell section with the second mould shell section in the adjustment direction; and means for adjusting and/or fixing a position of said guide part with respect to said frame.

The invention likewise provides a method for providing a smooth transition between adjacent mould shell sections for a mould shell for forming a wind turbine blade, comprising the steps of providing a first mould shell section comprising a first mould surface, a first connecting edge arranged laterally on the first mould shell section and said first mould surface having a first recessed portion adjoining said first connecting edge; providing a second mould shell section comprising a second mould surface, a second connecting edge arranged laterally on the second mould shell section and said second mould surface having a second recessed portion adjoining said second connecting edge, wherein the second connecting edge is shaped to match the first connecting edge; arranging the first mould shell section and the second mould shell section adjacent to each other such that the first and second connecting edges face each other; adjusting said first and second mould shell sections such that the first and second mould surfaces are approximately flush with respect to each other in areas of the mould surfaces adjacent to the recessed portions; and applying a bridging sheet in the first and second recessed portions such that the bridging sheet fills up the recessed portions.

The invention also provides a method for manufacturing a wind turbine blade, comprising the steps of providing a first mould shell section comprising a first mould surface, a first connecting edge arranged laterally on the first mould shell section and said first mould surface having a first recessed portion adjoining said first connecting edge; providing a second mould shell section comprising a second mould surface, a second connecting edge arranged laterally on the second mould shell section and said second mould surface having a second recessed portion adjoining said second connecting edge, wherein the second connecting edge is shaped to match the first connecting edge; arranging

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the first mould shell section and the second mould shell section adjacent to each other such that the first and second connecting edges face each other; adjusting said first and second mould shell sections such that the first and second mould surfaces are approximately flush with respect to each other in areas of the mould surfaces adjacent to the recessed portions; applying a bridging sheet in the first and second recessed portions such that the bridging sheet fills up the recessed portions; providing a mould shell comprising the first and second mould shell sections; and placing fibres and a resin in the mould shell, said fibres and said resin forming a first shell half of the wind turbine blade.

Further aspects of the invention are set forth in the dependent claims, the following description and the drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

Embodiments of the present invention are explained by way of example with respect to the accompanying drawings, in which:

FIG. 1 illustrates a large modern wind turbine according to the state of the art, as seen from the front,

FIG. 2 shows a single wind turbine blade as used in a wind turbine,

FIG. 3 shows a moulding apparatus for forming wind turbine blades,

FIG. 4 shows a cross sectional view of the moulding apparatus as seen from root mould portions,

FIG. 5a shows a cross sectional view of a separation line between mould shell sections before attachment as seen from the side,

FIG. 5b shows a cross sectional view of the mould shell sections of FIG. 5a with a bridging sheet after attachment,

FIG. 6 is a perspective view on the bottom side of the mould shell sections with protruding flanges,

FIG. 7 illustrates adjustment means according to an aspect of the invention with an associated transfer means,

FIG. 8a shows a perspective view of a mould shell section with a flange in a view to an engagement side of the flange and a number of transfer means attached to the flange,

FIG. 8b shows a perspective view of the mould shell section of FIG. 8a in a view to the side opposite to the engagement side of the flange,

FIG. 9 shows a perspective view of a mould shell section with a number of adjustment actuators of the adjustment means,

FIG. 10 shows a detail of mould shell sections engaging each other with an adjustment actuator and a spigot of a corresponding transfer means,

FIG. 11 shows a cross sectional view of the adjustment actuator and the transfer means according to the detail of FIG. 10, and

FIG. 12 shows a frame according to the invention without guide part 503.

DETAILED DESCRIPTION OF EMBODIMENTS

FIG. 1 shows a wind turbine generator 102 with a nacelle 104, and a hub 106 pivotally mounted to the nacelle 104 via a shaft. The nacelle 104 is mounted on a wind turbine tower 108 via a rotary joint. The hub 106 of the wind turbine includes three wind turbine blades 110 attached to the hub in a root end 114 of the blades. The hub 106 rotates around a shaft centre axis of the wind turbine in a rotational plane substantially perpendicular to the centre axis.

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Before proceeding further with a detailed description of the embodiments of the invention, some general aspects of the present invention are discussed. A mould shell for forming a wind turbine blade comprises a number of mould shell sections. Each mould shell section comprises a mould surface for receiving a fibre-reinforced composite for a blade, a connecting edge arranged laterally at the mould shell section, said connecting edge being adapted to provide an interface for another mould shell section of said mould, and said mould surface having a recessed portion adjoining said connecting edge, said recessed portion being adapted to accommodate a portion of a bridging sheet.

In some embodiments the surface of the recessed portion is adapted to enable adherence to a bridging sheet comprising a fibre-reinforced composite and/or a gel coat.

In some embodiments said recessed portion is dimensioned to allow a bridging sheet accommodated in the recessed portion to form a flush surface with the mould surface.

In some embodiments the recessed portion recesses from a normal level of the mould surface, the recessed portion comprising a straight section having an oblong cross section adjoining the connecting edges, and a tapered section tapering from the level of the straight section to the level of the normal level of the mould surface.

In some embodiments the mould shell section comprises an adjustment means for adjusting said mould shell section and another mould shell section to each other, wherein the adjustment means are arranged at the mould shell section adjacent to the connecting edge.

In some embodiments the mould shell section comprises a flange extending along the connecting edge, perpendicularly to the mould surface and on a side of the mould shell section opposing the mould surface, said flange being arranged for attachment of said mould shell section to a flange of another mould shell section and/or having facilities for attachment of adjustment means for adjusting said mould shell section to the other mould shell section.

In some embodiments said flange having preattached a part of the adjustment means.

In some embodiments said flange is adapted to be bolted to the flange of the other mould shell section.

A mould shell for forming a wind turbine blade comprises at least two such mould shell sections, wherein said mould shell sections engage each other along their connecting edges, and a bridging sheet accommodated in the recessed portions of the mould shell sections, wherein the bridging sheet is arranged to fill up the recessed portion.

In some embodiments said bridging sheet comprises a laminate comprising a woven fabric and/or a resin.

In some embodiments said bridging sheet comprises a gel coat covering the laminate and being matched to the mould surfaces of the mould shell sections.

For mutually adjusting first and second mould shell sections of a mould shell for forming a wind turbine blade adjustment means are provided, said adjustment means comprising a frame for attachment of said adjustment means to the first mould shell section, a guide part being adapted to engage the second mould shell section and being adapted to slide in the frame in an adjustment direction to guide an engagement position of the first mould shell section with the second mould shell section in the adjustment direction, and means for adjusting and/or fixing a position of said guide part with respect to said frame.

As used herein, a frame is understood as an arrangement of structural parts giving form or support to something.

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In some embodiments guiding an engagement position of the first mould shell section with the second mould shell section comprises guiding said second mould shell section in the adjustment direction.

In some embodiments said guide allows free travel of the engagement position transversally to the adjustment direction.

In some embodiments said means for adjusting and/or fixing a position comprise a worm gear and said guide part is adapted to slide in said frame in response to an action of the worm gear.

In some embodiments the means for adjusting and/or fixing a position comprises at least one screw threaded into said frame and engaging said guide part in an elongated groove extending in parallel to the adjustment direction.

In some embodiments said guide part is arranged on a side of the frame facing away from the side for attachment to a mould shell section.

In some embodiments the adjustment means further comprise a spigot for transferring the movement of the guide part to the second mould shell section.

In some embodiments the adjustment means comprise a transfer means attached to the second mould shell section, wherein said transfer means comprises said spigot, and wherein said guide part comprises an elongated aperture extending transversely to the adjustment direction and being adapted to engage the spigot.

In some embodiments said frame has a frame aperture, which is aligned to said elongated aperture of said guide part. The frame aperture extends in the adjustment direction and in the direction transversal to the adjustment direction by approximately at least the length of the elongated aperture of the guide part. The length of the elongated aperture refers to the dimension of the elongated aperture along its elongation.

In some embodiments said spigot is attached to the guide part. The respective other mould shell section may comprise a hole and the spigot may engage the hole. The hole may be shaped as an elongated aperture.

For a smooth transition between adjacent mould shell sections a first mould shell section is provided comprising a first mould surface and a first connecting edge arranged laterally on the first mould shell section, said first mould surface having a first recessed portion adjoining said first connecting edge. A second mould shell section is provided comprising a second mould surface and a second connecting edge arranged laterally on the second mould shell section, said second mould surface having a second recessed portion adjoining said second connecting edge, wherein the second connecting edge is shaped to match the first connecting edge. The first mould shell section and the second mould shell section are arranged adjacent to each other such that the first and second connecting edges face each other. The first and second mould shell sections are adjusted such that the first and second mould surfaces are approximately flush with respect to each other in areas of the mould surfaces adjacent to the first and second connecting edges. A bridging sheet is applied in the first and second recessed portions such that the bridging sheet fills up the recessed portions.

A smooth transition as used herein is meant to refer to a transition between two adjacent mould shell sections which does not induce a step in a laminate formed in the mould shell.

In some embodiments adjusting said first and second mould shell sections is carried out by adjustment means adapted to adjust a height of said first and second mould shell sections with respect to each other and to provide free

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travel of said first and second mould shell sections with respect to each other in a chord-wise direction. A chord-wise direction as used herein refers to a direction from a part of the mould shell provided for an intended trailing edge of a blade to be formed to a part of the mould shell provided for an intended leading edge of such blade. As used herein, a height refers to a distance to a support surface of a mould shell.

In some embodiments said adjustment means are fixed to the first and/or second mould shell sections adjoining the corresponding connecting edge.

In some embodiments said first mould shell section comprises a first flange running along the first connecting edge perpendicularly to the first mould surface on a side of the first mould shell section opposing the first mould surface, and said second mould shell section comprises a second flange running along the second connecting edge perpendicularly to the second mould surface on a side of the second mould shell section opposing the second mould surface, wherein these embodiments further comprise the step of arranging an adjustment actuator of said adjustment means on the first flange and arranging a spigot on the second flange, such that the spigot protrudes said first and second flanges and said adjustment actuator.

In some embodiments further adjustment means are arranged to adjust said first and second mould shell sections with respect to each other in a chord-wise direction and provide free travel of said first and second mould shell sections in a height direction.

In some embodiments said first and second mould shell sections are fixed to each other by means of bolts after being adjusted.

In some embodiments applying a bridging sheet comprises applying a laminate comprising a dry-woven fabric and/or a resin.

In some embodiments applying a bridging sheet comprises applying a gel coat and matching said gel coat up to said first and second mould surfaces.

For manufacturing a wind turbine blade a first mould shell section is provided comprising a first mould surface and a first connecting edge arranged laterally on the first mould shell section, said first mould surface having a first recessed portion adjoining said first connecting edge. A second mould shell section is provided comprising a second mould surface and a second connecting edge arranged laterally on the second mould shell section, said second mould surface having a second recessed portion adjoining said second connecting edge, wherein the second connecting edge is shaped to match the first connecting edge. The first mould shell section and the second mould shell section are arranged adjacent to each other such that the first and second connecting edges face each other. The first and second mould shell sections are adjusted such that the first and second mould surfaces are approximately flush with respect to each other in areas of the mould surfaces adjacent to the first and second connecting edges. A bridging sheet is applied in the first and second recessed portions such that the bridging sheet fills up the recessed portions. A mould shell is provided comprising the first and second mould shell sections, and fibres and a resin are placed in the mould shell. The fibres and the resin form a first shell half of the wind turbine blade.

In some embodiments the method further comprises the step of providing a second shell half of the blade, positioning the second shell half on the first shell half, and coupling the first and second blade shell halves to each other.

FIG. 2 shows a single wind turbine blade 20. The wind turbine blade 20 is an elongate structure having an outer

shell **24** disposed about an inner support element or spar **26**. The outer shell **24** may be optimally shaped to give the blade **20** the desired aerodynamic properties to generate lift, while the spar **26** provides the structural aspects (e.g., strength, stiffness, etc.) to blade **20**. The elongate blade **20** includes a root end **28** which is coupled to the central hub **18** when mounted to the hub **106**, and a tip end **30** on a side opposite to the root end **28**. The outer shell **24** includes a first, upper shell half **32** on the suction side of the blade **20**, and a second, lower shell half **34** on the pressure side of the blade **20**. The upper and lower shell halves **32**, **34** are coupled together along a leading edge **36** and a trailing edge **38** located opposite one another across a width of the blade **20**.

FIG. 3 shows a moulding apparatus **50** for forming rotor blades such as the blade **20** described above. The moulding apparatus **50** includes a first mould half **52** and a second mould half **54** positioned next to each other. The first mould half **52** is configured to be used to at least partially form the first shell half **32** of the blade **20** and the second mould half **54** is configured to be used to at least partially form the second shell half **34** of the blade **20**. To this end, the first mould half **52** includes a first contoured mould surface **58** generally corresponding to a negative of the contoured surface of the first shell half **32**. Similarly, the second mould half **54** includes a second contoured mould surface **62** generally corresponding to a negative of the contoured surface of the second shell half **34**. The first mould half **52** comprises a first mould shell half **52a** forming the first contoured mould surface **58** and a first support structure **52b** to support the first mould shell half **52a**. Likewise, the second mould half **54** comprises a second mould shell half **54a** forming the second contoured mould surface **62** and a second support structure **54b** to support the second mould shell half **54a**. In some embodiments, the first and second mould shell halves **52a**, **54a** are formed from a fibre-reinforced composite. In some embodiments the fibre-reinforced composite comprises resin, carbon fibre and/or fibre-glass. In some embodiments the first and second support structures are formed by metal frames such as steel frames.

The first mould shell half **52a** includes a first tip mould portion **53** for forming an upper tip end half of the upper shell half **32** and a first root mould portion **55** for forming an upper root end half of the upper shell half **32**. Likewise, the second mould shell half **54a** includes a second tip mould portion **57** for forming a lower tip end half of the lower shell half **34** and a second root mould portion **59** for forming a lower root end half of the lower shell half **34**.

As can be seen in FIG. 3, the first and second mould halves **52**, **54** have a split structure, separated along a first separation line **405** of the first mould shell half **52a** and a second separation line **406** of the second mould shell half **54a**. The first separation line **405** separates the first mould shell half **52a** into first mould shell sections **401**, **402** distributed in a longitudinal direction of the mould. The longitudinal direction extends from the first and second root mould portions **55**, **59** to the first and second tip mould portions **53**, **57**. In the depicted embodiment, the first mould shell sections **401**, **402** include a first root mould shell section **401** comprising the first root mould portion **55** and a tip mould shell section **402** comprising the first tip mould portion **53**. The second separation line **406** separates the second mould shell half **54a** into second mould shell sections **403**, **404** distributed in the longitudinal direction of the mould. In the embodiment the second mould shell sections **403**, **404** include a second root mould shell section **403** comprising the second root mould portion **59** and a second tip mould shell section **404** comprising the second tip mould

portion **57**. The first and second separation lines **405**, **406** extend transversely in relation to the longitudinal direction of the mould, in a chord-wise direction.

In some embodiments the first mould shell half **52a** is separated into a first root mould shell section **401** and a first tip mould shell section **402** to facilitate transporting and handling the first mould shell half **52a**. Likewise, the second mould shell half **54a** in the embodiment is separated into the second root mould shell section **403** and the second tip mould shell section **404**.

In the depicted embodiment the first support structure **52b** is separated into parts, one part supporting the first root mould shell section **401** and the other part supporting the tip mould shell section **402**. Likewise, the second support structure **54b** of the embodiment is separated into a part supporting the second root mould shell section **403** and another part supporting the second tip mould shell section **404**. In other embodiments root and tip mould shell sections may be arranged on a single support structure for each mould shell half.

In some embodiments one of the first and second mould halves **52**, **54** is movable relative to the other such that first and second mould halves **52**, **54** may be used to couple the first and second blade shell halves **32**, **34** to each other and to form the outer shell **24** of the blade **20**. In some embodiments, the moulding apparatus **50** has a clamshell configuration having a fixed mould half and a movable mould half movable relative to the fixed mould half so as to come to rest on top of the fixed mould half. For example, the first mould half **52** may be configured to be fixed to ground and the second mould half **54** may be configured to be movable relative to the first mould half **52** and relative to ground.

With such a clamshell configuration, the second mould half **54** may be movable relative to the first mould half **52** between an opened position, as illustrated in FIG. 3, and a closed position with the second mould half **54** resting on the first mould half such that the first and second contoured mould surfaces **58**, **62** form a cavity between the first and second mould halves **52**, **54**. In the opened position, the contoured surfaces **58**, **62** of the first and second mould halves **52**, **54**, respectively, are exposed such that the blade shell halves **32**, **34** may be formed therein. In the closed position with the second mould half **54** positioned on top of the first mould half **52** respective pairs of confronting edges of the first and second blade shell halves **32**, **34** may be generally aligned and in contact or near contact with each other so as to be coupled together.

In the depicted embodiment the moulding apparatus **50** includes a turner assembly **78** to effectuate movement of the second mould half **54** relative to the first mould half **52**. The turner assembly **78** is positioned between the first and second mould halves **52**, **54** when in the opened position. The turner assembly **78** includes a hinge or pivot mechanism. Accordingly, the second mould half **54** is adapted to rotate about a pivot axis defined by the hinge or the pivot mechanism.

FIG. 4 shows a cross section of the moulding apparatus **50** as seen from the first and second root mould portions **55**, **59**. In the depicted configuration the portions of the blade shell halves **32**, **34** forming the leading edge **36** are arranged adjacent to the turner assembly **78**. In this configuration the portions of the blade shell halves **32**, **34** forming the trailing edge **38** of the blade **20** are arranged on the outer sides of the moulding apparatus **50**. For the blade shell halves **32**, **34** fibre material and resin are applied in the first and second mould halves **52**, **54** from above.

The first and second mould halves **52**, **54** are positioned on a support surface **56**, such as the ground, floor, platform, etc. of a manufacturing facility.

Further embodiments of the first and second mould shell halves **52a**, **54a** have three or more mould shell sections each separated along separation lines. In some of the embodiments all separation lines run in a transversal direction and the mould shell sections are distributed in a longitudinal direction of the mould. In other embodiments the separation lines run in transversal and longitudinal directions.

The following description is equally applicable for the first mould half **52** and for the second mould half **54**, such that reference is made exemplarily to the root mould shell section **401** and the tip mould shell section **402** without distinguishing first and second mould shell sections. The teachings are likewise applicable for mould shells with three or more mould shell sections arranged longitudinally or chord-wise.

FIG. **5a** shows the separation line **405** between the root mould shell section **401** and the tip mould shell section **402** before attachment in a cross sectional view as seen from the side. The separation line **405** runs between a connecting edge **407** of the root mould shell section **401** and a connecting edge **408** of the tip mould shell section **402**. In FIG. **5a** the connecting edges **407**, **408** are shown with a gap in between, as it may be present before connecting the root mould shell section **401** and the tip mould shell section **402**. When the root mould shell section **401** and the tip mould shell section **402** are connected, there will be no gap left. In the depicted embodiment the connecting edges **407**, **408** extend transversely in relation to the longitudinal direction of the mould along the separation line **405**.

The root mould shell section **401** comprises a root section mould surface **411**, a root section back cover **415** and a root section spacing structure **413** sandwiched between the root section mould surface **411** and the root section back cover **415**. The root section mould surface **411** forms the contoured mould surface **58** in the area of the first root mould portion **55**. The root section back cover **415** and the root section spacing structure **413** provide a support of the root section mould surface **411** at least partially over the area of the root mould shell section **401**. In some embodiments the root section mould surface **411** and the root section back cover **415** are formed from a fibre-reinforced composite such as a resin reinforced by a fibre material such as glass fibre material or carbon fibre material, or a combination thereof. In some embodiments the root section mould surface **411** is covered with a coat. In some embodiments the coat is a release layer preventing adhesion of the resin to the root section mould surface **411**. In some embodiments the coat is a gel coat. In some embodiments, the root section spacing structure **413** is formed by a honeycomb structure.

Likewise, the tip mould shell section **402** comprises a tip section mould surface **412**, a tip section back cover **416** and a tip section spacing structure **414** sandwiched between the tip section mould surface **412** and the tip section back cover **416**. The tip section mould surface **412** forms the contoured mould surface **58** in the area of the first tip mould portion **53**. Further details of the first tip mould shell section **402** are arranged corresponding to the root mould shell section **401** as explained above.

The root section mould surface **411** has a recessed portion **419** adjoining the connecting edge **407** of the root mould shell section **401**. Likewise, the tip section mould surface **412** has a recessed portion **420** adjoining the connecting edge **408**. The recessed portions **419**, **420** extend along the

connecting edges **407**, **408**. In FIG. **5a** the recessed portions **419**, **420** are shown by reference to a dashed line signifying the normal level of the root and tip section mould surfaces **411**, **412**. When the root mould shell section **401** and the tip mould shell section **402** are in abutment, a bridging sheet may be accommodated in the recessed portions **419**, **420**, such that each of the recessed portions **419**, **420** accommodates a respective portion of the bridging sheet. Thereby the bridging sheet covers the separation line **405** between the root mould shell section **401** and the tip mould shell section **402**. To this end the recessed portions **419**, **420** are shaped according to the intended bridging sheet, for example providing space for a broad, lengthy and flat band.

FIG. **5b** shows the root mould shell section **401** and the tip mould shell section **402** after connection, with a bridging sheet **421** accommodated in the recessed portions **419**, **420**. The bridging sheet **421** fills up the recessed portions. An interface runs along the separation line **405** between the connecting edges **407**, **408**. The bridging sheet **421** is approximately flush with the root section mould surface **411** and the tip section mould surface **412**. Hence, a transfer of unevenness due to the interface between the connecting edges **407**, **408** to the blade shell half **32** is avoided to facilitate a smooth transition between mould shell sections **401**, **402**. The bridging sheet may also provide an airtight connection between the mould shell sections **401**, **402**, as required for some lamination procedures. The bridging sheet shall cover at least the interface between the connecting edges **407**, **408** in the area of the mould surfaces where blade shells will be formed. In some embodiments, the bridging sheet **421** may be formed of a fibre-reinforced composite such as a laminate of a resin reinforced by a fibre material, such as glass fibre material or carbon fibre material, or a combination thereof. In some embodiments the bridging sheet **421** and the recessed portions **419**, **420** are arranged to adhere to each other. Thereto, the surface of the recessed portions **419**, **420** is prepared to enable adherence to the bridging sheet, for example by providing a certain surface roughness and/or a certain material. In FIG. **5b** the bridging sheet **421** comprises a dry woven fabric **422** and a resin **423**. Further embodiments of the bridging sheet comprise a non-woven fabric. In some embodiments the bridging sheet **421** is covered with a coat. In some of these embodiments the coat is a release layer preventing adhesion of a resin for the structure of the blade shell half **32**. In some embodiments, the coat is formed as a gel coat. The coat may be shaped to adapt the bridging sheet to the root section mould surface **411** and the tip section mould surface **412**. In some embodiments each of the recessed portions **419**, **420** has a straight section with an oblong cross section adjoining the connecting edges **407**, **408**, and a tapered section tapering from the level of the straight section to the level of the normal level of the mould surfaces **411**, **412**. The straight section is particularly adapted to accommodate the fabric of the bridging sheet. The tapered section is particularly adapted to accommodate the resin and/or the gel coat. For example the straight section has a width of 60 mm and the straight section and the tapered section have a combined width of 100 mm. In further embodiments the ratio of the width of the straight section to the combined width is 3 to 5.

In FIGS. **5a** and **5b** the root mould shell section **401** and the tip mould shell section **402** are shown with respective flanges **409**, **410**. The flanges **409**, **410** extend transversely in relation to the longitudinal direction of the mould along the separation line **405** and the connecting edges **407**, **408**, perpendicularly to the root section mould surface **411** and the tip section mould surface **412**, and on a side of the mould

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shell sections **401**, **402** opposing the side with the recessed portion **419**, **420** and the mould surfaces **411**, **412**. When the root mould shell section **401** and the tip mould shell section **402** are engaged, the flanges **409**, **410** abut against each other.

The flanges **409**, **410** are arranged to provide facilities for adjustment means allowing adjustment of the mould shell sections **401**, **402** to each other. The flanges **409**, **410** are also arranged for attachment of the mould shell sections to each other. For this, attachment means such as rivets, bolts or screw bolts are provided. Thereby, the adjustment and/or attachment means adjoin the connecting edges **407**, **408**, such that displacement of a connecting edge with respect to the other connecting edge due to bending of one of the mould shell sections **401**, **402** is avoided during an adjusting procedure as well as during use when the sections are connected. As the connecting edges **407**, **408** support each other, they prevent that the mould shell sections **401**, **402** incline towards the connecting edges **407**, **408**. Accordingly, alignment of the root section mould surface **411** and the tip section mould surface **412** is improved.

FIG. 6 is a perspective view of the flanges **409**, **410** of the root mould shell section **401** and the tip mould shell section **402**. Along the flange **409** of the root mould shell section **401a** a number of adjustment means **500** are provided. The shown parts of the adjustment means **500** are adjustment actuators, which are complemented by transfer means arranged on the flange **410** of the tip mould shell section **402** at positions corresponding to the adjustment actuators. In some embodiments the adjustment actuators are arranged on the flanges **409**, **410** facing away from the respective other mould shell section. In these embodiments the transfer means protrude through the flanges **409**, **410** to engage the adjustment actuators.

In the shown embodiment the flanges **409**, **410** comprise a number of holes **424**. The holes in the flanges **409**, **410** of the root mould shell section **401** and the tip mould shell section **402** are approximately aligned to each other. The holes **424** provide facilities for attachment means for attaching the root mould shell section **401** and the tip mould shell section **402** to each other. Such attachment means are, for example, rivets, bolts or screw bolts. The flanges **409**, **410** also provide facilities for the attachment of the adjustment means **500** and the transfer means. The holes provide passages for the transfer means.

FIG. 7 shows embodiments of the adjustment actuator **501** and the transfer means **551**. The adjustment actuator **501** comprises a guide part **503** for a corresponding part of the transfer means **551** and a frame **502** accommodating the guide part **503**. The guide part **503** is guided linearly in the frame to be slidable to and fro in an adjustment direction. The guide part **503** comprises an elongated aperture **504**, which elongates transversally to the adjustment direction. The frame **502** comprises a frame aperture which is aligned to the elongated aperture **504** of the guide part **503**. The frame provides facilities **508** for attachment of the adjustment actuator **501** to the flanges **409**, **410** of one of the mould shell sections **401**, **402**.

In an embodiment, the frame aperture extends along the entire frame and divides the frame **502** into two parts.

The frame **502** also comprises a gear as a means **505** for adjusting a position of the guide part **503** with respect to the frame **502** in the adjustment direction. In some embodiments the gear **505** comprises a gear, such as a worm gear, which shifts the guide part **503** with respect to the frame **502** in the adjustment direction in response to a rotation of the worm gear. The gear **505** is arranged between the frame **502** and

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the guide part **503**, and engages both. In some embodiments the worm gear is a grub screw. In some embodiments the gear **505** is actuated manually, for example by a screw driver. In other embodiments the gear **505** is actuated by a hydraulic or electric actuator.

The frame **502** further comprises means **506** for fixing a position of the guide part **503** with respect to the frame **502**. The guide part **503** comprises at least one elongated groove **507** extending in parallel to the adjustment direction. The means **506** for fixing a position engages the guide part **503** in the at least one elongated groove **507**. In some embodiments the means **506** for fixing a position is a hexagon socket screw.

In the depicted embodiment the frame **502** encloses the guide part **503** from two opposite sides **511** to provide the linear guiding for the guide part **503**. A third side **512** is arranged between the opposite sides **511** and in parallel to the adjustment direction next to the guide part **503**. The third side **512** comprises a bearing for the gear **505** of the guide part **503** and the frame aperture. The at least one elongated groove **507** is arranged adjacent to at least one of the opposite sides. The means **506** for fixing a position of the guide part **503** penetrates an interface between the at least one of the opposite sides and the guide part **503** in parallel to the interface. Therefore, the at least one of the opposite sides **511** can prop up the means **506** for fixing a position against the guide part **503** and the respective other opposite side **511**.

In the depicted embodiment four hexagon socket screws are provided as means for fixing a position, two hexagon socket screws penetrating the interface between each of the opposite sides **511** and the guide part **503**. The hexagon socket screws engage the guide part **503** in four elongated grooves, two of which are respectively provided on each side of the guide part **503** adjacent to the opposite sides **511**. The hexagon socket screws are threaded into the third side **512**. The facilities **508** for attachment of the adjustment actuator **501** are arranged adjacent to the outer sides of the opposite sides.

The transfer means **551** comprises a spigot **552** and a base plate **553** with the spigot **552** protruding perpendicularly from the base plate **553**. The spigot **552** has an approximately cylindrical shape and a rounded tip. The base plate comprises facilities **558** for attachment of the transfer means **551** to the respective other flange **410**, **409**.

The elongated aperture **504** extends in the adjustment direction by approximately the diameter of the spigot **552** and transversally to the adjustment direction by more than the diameter of the spigot **552**. The elongated aperture acts as a guide for the transfer means **551**, guiding the transfer means in the adjustment direction and allowing free travel of the transfer means transversally to the adjustment direction. Accordingly, the spigot **552** is guided by the elongated aperture **504** in the adjustment direction and may travel freely along the elongation of the elongated aperture **504**. The frame aperture extends both in the adjustment direction and transversally to the adjustment direction by approximately at least the length of the elongated aperture **504** of the guide part. The length of the elongated aperture refers to the dimension of the elongated aperture along its elongation. Accordingly, the spigot **552** may travel freely in the frame aperture both in the adjustment direction and along the elongation of the elongated aperture **504**.

FIG. 8a shows a number of the transfer means **551** attached to the flange **410** of the tip mould shell section **402** with a view to an engagement side of the flange **410**. Additionally, details of the transfer means **551** are shown in

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an enlarged view A. The spigot **552** of the transfer means **551** is arranged to protrude the flange **410** through one of the holes **424** and to stick out from the flange **410** on the engagement side. A number of fastening members **561** penetrates the flange **410** to engage the base plate **553**, which is arranged on a side of the flange **410** opposite to the engagement side.

FIG. **8b** shows the transfer means **551** attached to the flange **410** of the tip mould shell section **402** with a view to the side opposite to the engagement side of the flange **410**. Details of the transfer means **551** are shown in an enlarged view B. The fastening members **561** penetrate the base plate **553**, such that their endings are visible.

FIG. **9** shows a number of first and second adjustment actuators **501a**, **501b** such as the adjustment actuator **501** described above attached to the flange **409** of the root mould shell section **401**. Furthermore, details of the first and second adjustment actuators **501a**, **501b** are shown in enlarged views C, D. The first and second adjustment actuators **501a**, **501b** are mounted to the flange **409** such that their respective elongated aperture **504** is aligned to one of the holes **424** of the flange **409**. In the enlarged view C a first adjustment actuator **501a** is oriented with its elongated aperture **504a** elongating transversally to the root mould shell section **401** in a chord-wise direction. In the enlarged view D of the depicted embodiment the second adjustment actuator **501b** is oriented such that its elongated aperture **504b** is oriented perpendicularly to the elongated aperture **504a** of the first adjustment actuator **501a**. Accordingly, the adjustment directions of the first and second adjustment actuators **501a**, **501b** are perpendicular to each other.

FIG. **10** shows a detail of the root mould shell section **401** and the tip mould shell section **402** engaging each other with the adjustment actuator **501** and a spigot **552** of a corresponding transfer means. The adjustment actuator **501** is attached to the flange **409** of the first root mould shell section, for example by fastening members engaging the facilities **508** for attachment of the adjustment actuator **501**. The flanges **409**, **410** abut against each other. The respective holes **424** in the flanges **409**, **410** are aligned to each other to accommodate attachment means such as screw bolts. The spigot **552** of the transfer means **551** protrudes one of the holes **424** of the flange **410** of the tip mould shell section **402**, a corresponding hole **424** of the root mould shell section **401** and the elongated aperture **504** of the adjustment actuator **501**, such that the spigot **552** engages the elongated aperture **504**. The elongated aperture **504** elongates transversally to the root mould shell section **401** and the tip mould shell section **402** in a chord-wise direction. Accordingly, the spigot **552** can travel freely transversally to the mould shell sections **401**, **402** in a chord-wise direction and is guided to adjust a height of the root mould shell section **401** with respect to the tip mould shell section **402**.

FIG. **11** is a cross sectional view of the adjustment means **500** with the adjustment actuator **501** and the transfer means **551** according to the detail of FIG. **10**. The transfer means **551** is attached to the flange **410** of the tip mould shell section **402** by the fastening members **561** engaging the facilities **558** for attachment of the transfer means **551**. In some embodiments the fastening members **561** are screws. The spigot **552** passes the flange **409** of the root mould shell section **401** via a hole **424a**, which has a larger diameter than the spigot **552**, such that the spigot **552** may travel transversally to the hole **424**. Likewise, as the frame aperture **509** was explained above to exceed the dimensions of the elongated aperture **504**, the spigot **552** may travel freely transversally to the frame aperture **509**.

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The frame **502** also bears and abuts the gear **505** of the guide part **504**. In the depicted embodiment the gear **505** is a worm gear engaging the guide part **504** in a threaded groove **510** extending in parallel to the adjustment direction **520**. When the worm gear is rotated, the guide part **503** moves linearly in the adjustment direction **520**.

In FIG. **11** the spigot **552** is also shown to abut against the guide part **503** in the elongated groove **504** from both sides in the adjustment direction **520**. Accordingly, when the guide part **503** is moved, the guide part **503** engages the spigot **552** and the spigot **552** is taken along, such that the movement of the guide part **503** is transferred to the flange **410** and the tip mould shell section **402**. Accordingly, the flange **410** and the tip mould shell section **402** move with respect to the flange **409** and the root mould shell section **401** in the adjustment direction **520** in response to a rotation of the worm gear.

FIG. **12** shows the frame **502** without guide part **503**. The frame aperture **509** is arranged in the centre, with the spigot **552** in the centre of the frame aperture **509** being spaced from the boundary of the frame aperture **509**. The opposite sides **511** are arranged laterally. The facilities **508** for attachment are provided on the periphery of the frame **502**. The bearing **513** for the gear **505** described above is arranged on the third side **512** between the opposite sides **511**.

In an alternative embodiment a spigot is attached to the guide part and engages a hole in the respective other mould shell section. The hole may have the shape of an elongated aperture to provide engagement in an adjustment direction and, to a certain extent, to provide free travel in a direction perpendicular to the adjustment direction.

For providing a smooth transition between the adjacent root mould shell section **401** and the tip mould shell section **402**, the mould shell sections **401**, **402** are initially positioned such that their connecting edges **407**, **408** and their flanges **409**, **410** engage each other.

In a further step, for providing adjustment means the adjustment actuator **501** is applied to one of the flanges **409**, **410** of the mould shell sections **401**, **402** and the transfer means **551** is applied to the respective other flange **410**, **409**, such that the spigot **552** protrudes both flanges and the frame **502** approximately perpendicularly, and engages the guide part **503** in the elongated hole **504**. The adjustment actuator **501** is oriented to the mould shell sections **401**, **402** to determine the adjustment direction **520**. In some embodiments the adjustment direction **520** is oriented to provide height adjustment of the mould shell sections **401**, **402** to each other.

Further adjustment means may be applied to provide height adjustment or chord-wise adjustment of the mould shell sections **401**, **402** to each other.

In a further step the adjustment actuator **501** is actuated and adjusts the mould shell sections **401**, **402** with respect to each other until their respective mould surfaces **411**, **412** are approximately flush with respect to each other in areas of the mould surfaces **411**, **412** adjacent to the first and second connecting edges **407**, **408**.

Additionally or alternatively to the adjustment means the bridging sheet **421** is inserted in the recessed portions **419**, **420** of the mould shell sections **401**, **402**, such that portions of the bridging sheet **421** are approximately evenly distributed between both recessed portions **419**, **420**, whereby the interface between the mould shell sections **401**, **402** is covered. The bridging sheet is arranged to cover at least the interface between the mould shell sections **401**, **402** in the area of the mould surfaces where blade shells will be

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formed. In some embodiments inserting the bridging sheet 421 comprises applying a dry woven fabric in a first step and infusing a resin in a next step to obtain a fibre-reinforced composite layer. The fibre reinforced composite layer is covered with a coating, such as a gel coat, which is distributed to match up the mould surfaces 411, 412 of the mould shell sections 401, 402.

The invention claimed is:

1. A mould shell for forming a wind turbine blade comprising a first mould shell section having a longitudinal axis, the first mould shell section further comprising:

a first mould surface for receiving a fibre-reinforced composite for the wind turbine blade; and

a first connecting edge arranged laterally in relation to the longitudinal axis of the first mould shell section in a chord-wise direction of the first mould shell section, said first connecting edge being adapted to provide an interface for another mould shell section of said mould shell,

wherein said first mould surface includes a first recessed portion adjoining said first connecting edge, said first recessed portion being adapted to accommodate a portion of a bridging sheet, and

wherein the first recessed portion recesses from a normal level of the first mould surface, the first recessed portion comprising a straight section having an oblong cross section adjoining the first connecting edge, and a tapered section tapering from the level of the straight section to the level of the normal level of the first mould surface.

2. The mould shell according to claim 1, wherein said first recessed portion is dimensioned to allow the bridging sheet accommodated in the first recessed portion to form a flush surface with the first mould surface.

3. The mould shell according to claim 1, further comprising an adjustment device for adjusting said first mould shell section and another mould shell section relative to each other, wherein the adjustment device is arranged at the first mould shell section adjacent to the first connecting edge.

4. The mould shell according to claim 1, further comprising a flange extending along the first connecting edge, perpendicularly to the first mould surface and on a side of the first mould shell section opposing the first mould surface, said flange being arranged for attachment of said first mould shell section to a flange of another mould shell section and/or having facilities for attachment of an adjustment device for adjusting said first mould shell section relative to the other mould shell section.

5. The mould shell according to claim 1, further comprising a second mould shell section having a longitudinal axis, the second mould shell section comprising:

a second mould surface for receiving a fibre-reinforced composite for the wind turbine blade; and

a second connecting edge arranged laterally in relation to the longitudinal axis of the second mould shell section in a chord-wise direction of the second mould shell section,

wherein said second mould surface includes a second recessed portion adjoining said second connecting edge, said second recessed portion being adapted to accommodate a portion of a bridging sheet,

wherein the second recessed portion recesses from a normal level of the second mould surface, the second recessed portion comprising a straight section having an oblong cross section adjoining the second connect-

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ing edge, and a tapered section tapering from the level of the straight section to the level of the normal level of the second mould surface,

wherein said first and second mould shell sections engage each other along their respective connecting edges, and wherein the mold shell further comprises a bridging sheet accommodated in the recessed portions of the first and second mould shell sections, the bridging sheet being arranged to fill up the recessed portions.

6. The mould shell according to claim 5, wherein said bridging sheet comprises a gel coat covering the laminate and being matched to the mould surfaces of the mould shell sections.

7. The mold shell according to claim 5, further comprising an adjustment device for mutually adjusting the first and second mould shell sections of a mould shell for forming the wind turbine blade, said adjustment device comprising:

a frame for attachment of said adjustment device to the first mould shell section;

a guide part being adapted to engage the second mould shell section and being adapted to slide in said frame in an adjustment direction to guide an engagement position of the first mould shell section with said second mould shell section in the adjustment direction; and

means for adjusting and/or fixing a position of said guide part with respect to said frame.

8. The mould shell according to claim 7, wherein guiding an engagement position of the first mould shell section with said second mould shell section comprises guiding said second mould shell section in the adjustment direction.

9. The mould shell according to claim 7, wherein said guide allows free travel of the engagement position transversally to said adjustment direction.

10. The mould shell according to claim 7, wherein said means for adjusting and/or fixing a position comprise a worm gear and said guide part is adapted to slide in said frame along the adjustment direction in response to an action of the worm gear.

11. The mould shell according to claim 7, further comprising a spigot for transferring the movement of the guide part to the second mould shell section.

12. The mould shell according to claim 11, further comprising a transfer device attached to the second mould shell section, wherein said transfer device comprises said spigot, and wherein said guide part comprises an elongated aperture extending transversely to the adjustment direction and being adapted to engage the spigot, and wherein said frame has a frame aperture, which is aligned to said elongated aperture, said frame aperture extending in said adjustment direction and said direction transversal to said adjustment direction by approximately at least the length of the elongated aperture of the guide part.

13. The mould shell according to claim 11, wherein said spigot is attached to the guide part.

14. A method for providing a smooth transition between adjacent mould shell sections for a mould shell for forming a wind turbine blade, comprising:

providing a first mould shell section comprising a first mould surface for receiving a fibre-reinforced composite for the wind turbine blade and a first connecting edge arranged laterally in relation to a longitudinal axis of the first mould shell section in a chord-wise direction of the first mould shell section, wherein the first connecting edge is adapted to provide an interface for another mould shell section of the mould shell, wherein the first mould surface includes a first recessed portion adjoining the first connecting edge, the first recessed

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portion being adapted to accommodate a portion of a bridging sheet, and wherein the first recessed portion recesses from a normal level of the first mould surface, the first recessed portion comprising a straight section having an oblong cross section adjoining the first connecting edge, and a tapered section tapering from the level of the straight section to the level of the normal level of the first mould surface;

providing a second mould shell section comprising a second mould surface for receiving a fibre-reinforced composite for the wind turbine blade and a second connecting edge arranged laterally in relation to a longitudinal axis of the second mould shell section in a chord-wise direction of the second mould shell section, wherein the second mould surface includes a second recessed portion adjoining the second connecting edge, the second recessed portion being adapted to accommodate a portion of a bridging sheet, and wherein the second recessed portion recesses from a normal level of the second mould surface, the second recessed portion comprising a straight section having an oblong cross section adjoining the second connecting edge, and a tapered section tapering from the level of the straight section to the level of the normal level of the second mould surface,

arranging the first mould shell section and the second mould shell section adjacent to each other such that the first and second connecting edges face each other;

adjusting said first and second mould shell sections such that the first and second mould surfaces are approximately flush with respect to each other in areas of the mould surfaces adjacent to the recessed portions; and

applying a bridging sheet in the first and second recessed portions such that the bridging sheet fills up the recessed portions.

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15. The method according to claim 14, wherein adjusting said first and second mould shell sections is carried out by an adjustment device adapted to adjust a height of said first and second mould shell sections with respect to each other and to provide free travel of said first and second mould shell sections with respect to each other in a chord-wise direction.

16. The mould shell according to claim 5, wherein said first mould shell section comprises a first flange running along the first connecting edge perpendicularly to the first mould surface on a side of the first mould shell section opposing the first mould surface, and said second mould shell section comprises a second flange running along the second connecting edge perpendicularly to the second mould surface on a side of the second mould shell section opposing the second mould surface, and further comprising an adjustment actuator of an adjustment device arranged on the first flange and a spigot on the second flange, such that the spigot protrudes said first and second flanges and said adjustment actuator.

17. The method according to claim 14, wherein applying a bridging sheet comprises applying a gel coat and matching said gel coat up to said first and second mould surfaces.

18. A method for manufacturing a wind turbine blade, comprising:

- providing a mould shell comprising the first and second mould shell sections;
- providing a smooth transition between the first and second mould shell sections according to claim 14; and
- placing fibres and a resin in the mould shell, said fibres and said resin forming a first shell half of the wind turbine blade.

19. The method according to claim 18, further comprising providing a second shell half of the blade, positioning the second shell half on the first shell half, and coupling the first and second blade shell halves to each other.

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